

Date: Wednesday, 3/8/2006 10:37:48 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHROUD ASSEMBLY
Job Number : 26107 <i>2</i>	
Estimate Number : 12303	
P.O. Number : N/A	Part Number : D34673
This Issue : 3/8/2006 S.O. No. : N/A	Drawing Number : D3467 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <i>See</i> COMMENT BELOW	Due Date : 3/31/2006
Checked & Approved By : <i>06.03.08</i>	Qty: <i>20</i> Um: Each
Comment : est rev. A 06.02.06 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting Issue P/O: *00000768* *06/03/09*
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3467 flat pattern D3467-PF *06/03/09*
 Material release note required

2.0	D34673F	TUBE FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total : *20* 12.0000 Each(s)
 DOUBLER FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Roll as per dwg D3467
 2- Spot weld as per dwg D3467 & QSI004
 3-Form bead as per dwg D3467

SB 06/04/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/28	4	One taken Ser template	12/03/28	1		12/03/28	12/03/28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/26

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:37:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26107

Part Number: D34673

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.04.25 (17)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06.04.25 (17)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.04.26 (17)

Job Completion



u 06.04.26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

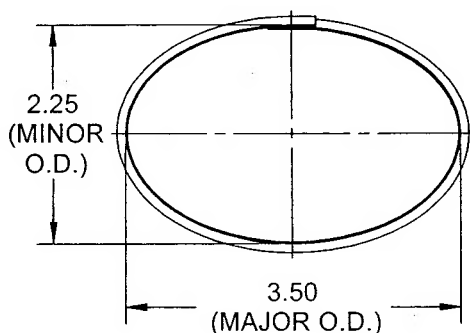
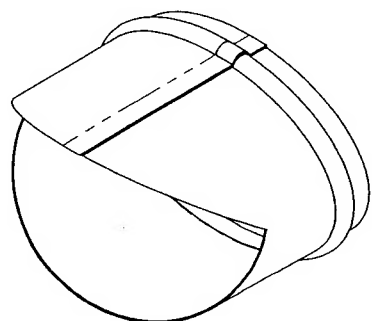
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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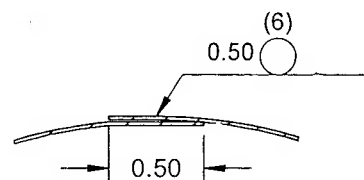
NOTE: Date & initial all entries

PRELIMINARY ISSUE

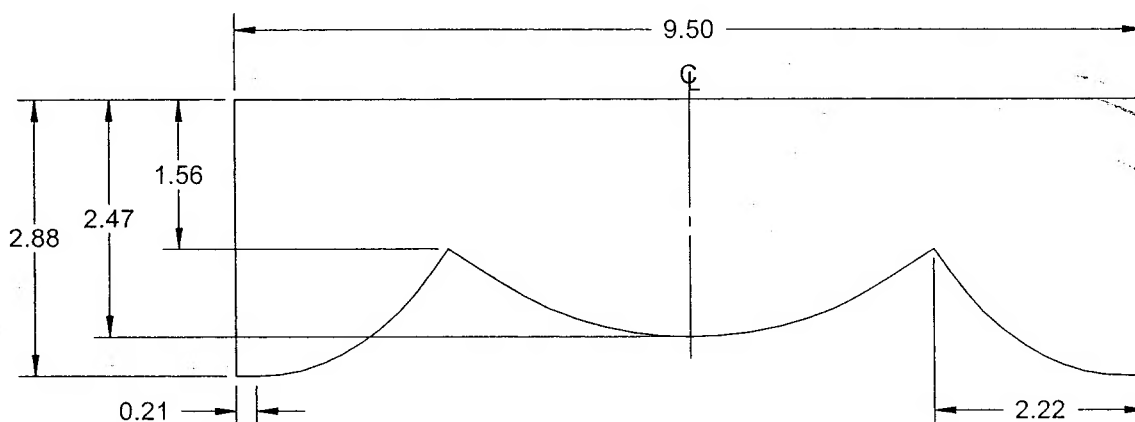
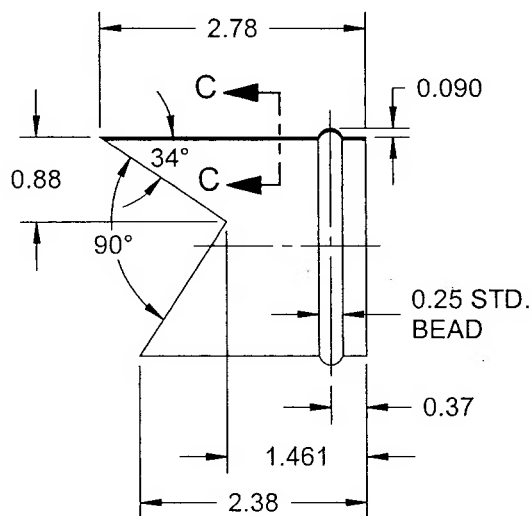
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 7 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



D3467-3 TUBE DETAIL



SECTION C-C
SCALE 1:1



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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MAY-17-2005 18:05

FROM INTEGRIS

253-288-8833

T-726 P-007/015 F-597

INDUSTRIAL LASER P.O. - 110880 S.O. - 374786 ITEM 01 - 3 SHES

		AK Steel Corporation Metallurgical Test Report Construction Works Construction, OH 43812		Fig 1 Lead No. 710672 SRV No. 710672							
		INTEGRIS METALS 306 W. STREET ALBANY, WA 98001		MILL ORDER NO. 77155-0191 PROCESSOR ORDER NO. 42715-01 BUYER'S ORDER NO. 42715-01							
INTEGRIS METALS P.O. BOX 340 ALBANY, WA 98001		INTEGRIS METALS 306 W. STREET ALBANY, WA 98001		FACTORY NO. 74451491 EXHAUSTION UNIT - 2 PRODUCT - METRIC UNITS DIMENSION 4000 X COIL							
SKU ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT							
SK07B343	1	710672		846 LBS. 402 KG.							
SK07B344	1	710672		846 LBS. 402 KG.							
SK07B345	1	710672		846 LBS. 402 KG.							
SK07B346	1	710672		846 LBS. 402 KG.							
SK07B347	1	710672		846 LBS. 402 KG.							
TOTAL SKIDS		TOTAL NET WEIGHT		3240 LBS. 1470 KG.							
L-Label Analysis of Heat P-Product Analysis of Parent Coil CHEMICAL ANALYSIS											
ID	C	MIN	P	S	SI	CR	N	MO	N	CU	CO
T 710672	.049	1.39	.027	.001	.35	18.18	8.05	.35	.04	.30	.12
SHIPPING DATE: 09/12/2005 REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.											
PRODUCT DESCRIPTION CR. SET TYPE 304 STAINLESS STEEL FINISH BLT EDGE * AND SHL & ALL TONG RINGS HAVE BEEN HOT ROLLING ROLLED TO OR NOTED DIMENSIONS * A SIZE 240 - 04 EX PARA 3.1.1 B LONG WILL BE DIMENSIONED BY PART 8 9 * PART 4 40 - 01 EX PARA 19.1.1 B LONG WILL BE DIMENSIONED BY PART 8 9 EX PARA 20.1.1.3 COIL WILL BE TAPPED ON OUTSIDE ONLY * AS PER 8 666 - 03 * IN-011 0 * BUYER PART# 74251497 * AS PER 8 260 SECTION IT PART 8 (2004 ED. 2002 AMENDMENT) EX PARA 3.1.1.1 B LONG WILL BE DIMENSIONED BY PART 8 9 * EX-10204 3.1.1.1											
PARENT COIL	FROM	DIR	COND	5 B LONG	TENSILE	YS	ROCKWELL	ROCKWELL			
ID	(870)	(L, T, D)		2 INCH	STRENGTH	(KSI)	HARDNESS	HARDNESS			
*** CONTINUED ON NEXT PAGE ***											

604-946-4553
 ATTN: JETE
 3/17/06

Ryerson

3/17/2006 1:57

PAGE 002/002

Fax Server

MAY-17-2005 16:05

FROM-INTEGRIS

253-288-8833

T-726 P.008/015 F-537



AK Steel Corporation

Metallurgical Test Report

Coshocation Works

Coshocation, OH 43812

Page 2

Lot# No. 7410672
SEN No. 7410672

MILL ORDER NO. PROCESSOR ORDER NO. BUYER'S ORDER NO.

47548-0191 427136-01

427136-01

PART NO.

7425107

ENGLISH UNITS - PRODUCT - METRIC UNITS
971 R006 48600 X COILINTEGRIS METALS
PO BOX 390
MINNEAPOLIS, MN 55440INTEGRIS METALS
306 B STREET
AUBURN, WA 98001

C O S H O C O S H A C O N

S H I P T O

MILL ORDER NO.

PROCESSOR ORDER NO.

BUYER'S ORDER NO.

PARENT COIL

ASTM A36

BEND 180

IT

PARENT COIL

POS DER COND

ASTM A36

ID (W/D (L, T, D)

PARENT COIL

POS DER COND

ASTM A36

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BEND 180

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PARENT COIL

POS DER COND

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K9
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 11G PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aB; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 INDUSTRIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GUELPH, ONT. K123
Control #: 50C60214
Part #: 74274441
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDS. LASER

TO 110880

S/P 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.